



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE703A95-0520-01-18

Job Sheet 197410



Part No: RBE703A95-0520-01-18

Job Qty: 8 pcs

Part Name: Quill Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/5/19

Job Tracking No:

Due Date: 10/25/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE703A95-0520-01 Rev K IPP Rev A 18.01.23 New issue DP Verify DD/IPP Rev.B 19.02.27 drawing revision DP Verify DD/IPP Rev. C 19.05.23 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	8 pcs	10/25/19		0.00	1.60	Small Fab - 1		M/L
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	8 pcs	10/25/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
120	Packaging 3-1 - Stock - B4B	8 pcs	10/25/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S223831



Part: RBE703A95-0520-01-18

Job No: 197410

Serial No/Batch: S223831

Revision: K

Inspector:

Exp Date:

Instructions:

Date: 10/18/19

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				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B	DA:	
				Packaging 3 - 7 - B4B	28	
				Packaging 3 - 8 - B4B	9-89	
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
130	QC 21 - SA	8 pcs	10/25/19	0.00 0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-59

Part Op **100** - Assemble as per DWG. See note 8 and 9.
 Descriptions: **110** - QC5- Inspect part completeness to step on W/O
120 - Identify as per dwg & Stock Location: _____
130 - QC21- Final Inspection - Work Order Release

OCT 24 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
416 56 144 9263K519	O-ring	8 Ea (1 ea)	100-Small Fab - 1	519230
93600A252	316 SS Dowel Pin 2.5 mm Dia. x 6 mm Lg.	24 Ea (3 ea)	100-Small Fab - 1	3x5194315 21x5198 270
RBE703A95-0520-01-1	Quill	8 pcs (1 ea)	100-Small Fab - 1	5183156

Job Allocations

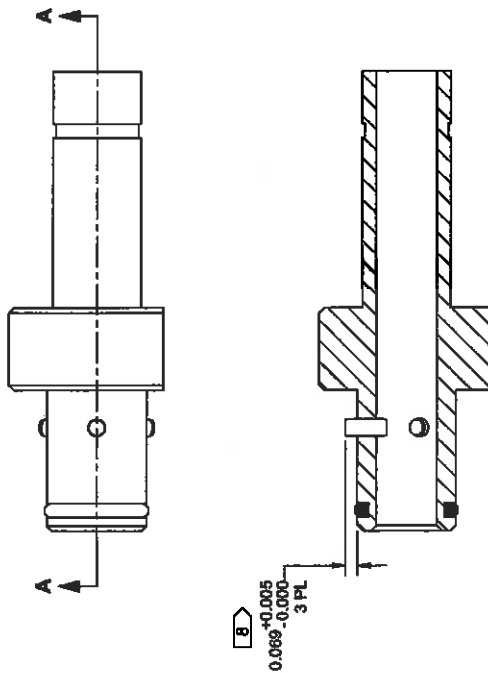
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	9263K519	8	33	0
	93600A252	24	55	0
	RBE703A95-0520-01-1	8	8	0

Part Specifications

Specifications could not be found.

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ITEM #	QTY	PART #	PART TITLE
-1	1	RBE703A95-0520-01-1	QUILL
21	1	McMaster9283K519 OR EQUIV.	VITON O-RING 11 mm ID. X 15 mm OD. X 2 mm THK.
22	3	McMaster983600A252 OR EQUIV.	316 SS DOWEL PIN 2.5 mm DIA. X 6 mm LG.



SECTION A-A

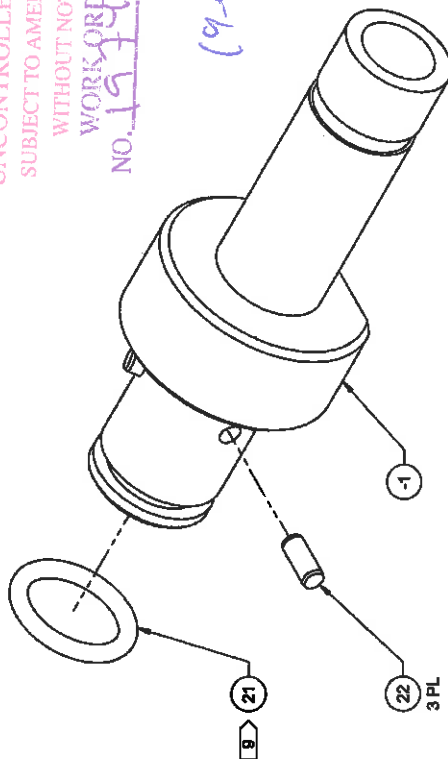
NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: XX = $\pm 0.1^\circ$ / $\pm 1^\circ$
XX = $\pm 0.01^\circ$ / $\pm 0.5^\circ$
XXX = $\pm 0.005^\circ$ / $\pm 0.1^\circ$
XXXX = $\pm 0.0005^\circ$ / $\pm 0.05^\circ$

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLY: N/A
- 8) APPLY RETAINING CONFOUND LOCKTITE 620 OR EQUIVALENT ON MATING SURFACES
- 9) WHEN PRESS FIT ITEM 22 WITH ITEM 1, AND REMOVE EXCESS
- 10) APPLY MOLYKOTE 65 OR EQUIVALENT ON ITEM 21 THEN ASSEMBLE WITH ITEM 1 AND REMOVE EXCESS

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.008^\circ$

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 197410
1105
19-07-08



RBE703A95-0520-01-18 QUILL ASSEMBLY

DESIGN	KPT	LM86	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	LM86		
CHECKED	KPT		
MFG. APPR.	DJ		
APPROVED	WSP		
DATE	4/24/2019		
TOOL PART #	RBE703A95-0520-01	REV. K	
TITLE	ENGINE & HYDRAULIC DRAIN TUBE	SHEET 3 OF 7	
SCALE	NTS		
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Entered:

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only



Job: _____		DISPOSITION				DEPARTMENT/PROCESS				MRB (QS1042)							
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐				Skid-tube ☐ Machining ☐ Large Fab ☐				Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐				Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date:		Sequence #:		QTY Affected:													
Description Work Order Deviation						Disposition											
Root Cause						FAULT CATEGORY											
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐						Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐											
						Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐											
Other/Details:						Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐											
						Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐											
Completed By						Lead hand / Supervisor											
QC / QA Coordinator																	